



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RBEM652V3002101-M

Job Sheet 177785



Part No: RBEM652V3002101-M

Job Qty: 1 ea

Part Name: Tail Gear Box Input Seal Exchange



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/17/18

Job Tracking No:

Due Date: 8/20/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM652V3002101-M Rev D IPP Rev A 18.04.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/20/18	8/20/18	0.00	0.00	Start Up Small Fab-4		MLC
110	Small Fab	1 pcs	8/20/18	8/20/18	0.00	1.00	Small Fab-4		MLC
120	QC	1 pcs	8/20/18	8/20/18	0.00	0.00	QC5		38
130	Packaging	1 pcs	8/20/18	8/20/18	0.00	0.00	Packaging3-1		MLC
140	QC21-FG	1 Ea	8/20/18	8/20/18	0.00	0.00	QC21		21 NOV 20 2018

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1510 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBEM652V3002101-M-21 to RBEM652V3002101-M-19 foam as per DWG. 6-Glue foams to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	3089129
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	3021040
APP-1510-E	Case	1 Ea (1 ea)	110-Small Fab	3100813
RBEM652V3002101-M-17	Bottom Foam use in case APP-1510-E	1 pcs (1 ea)	110-Small Fab	3100811
RBEM652V3002101-M-19	Top Foam use in case APP-1510-E	1 pcs (1 ea)	110-Small Fab	3100812
RBEM652V3002101-M-21	Content Placard	1 Ea (1 ea)	110-Small Fab	3110165
RBEM652V3002101-M-3	Guide	1 Ea (1 ea)	110-Small Fab	3110779
RBEM652V3002101-M-35	Lid Assembly	1 Ea (1 ea)	110-Small Fab	3129428
RBEM652V3002101-M-5	Base	1 Ea (1 ea)	110-Small Fab	3110895

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	4	571	0
	RB41011	1	803	0
110-Small Fab	APP-1510-E	1	2	0
	RBEM652V3002101-M-17	1	1	0
	RBEM652V3002101-M-19	1	1	0
	RBEM652V3002101-M-21	1	0	0
	RBEM652V3002101-M-3	1	0	0
	RBEM652V3002101-M-35	1	0	0
	RBEM652V3002101-M-5	1	0	0

10

240
80
100

Part Specifications

Specifications could not be found.

Plex 8/20/18 1:34 PM dart.logan.david



Container No: S129481



Part: RBEM652V3002101 - M

Job No: 177785

Serial No/Batch: S129481

Revision: B

Inspector:

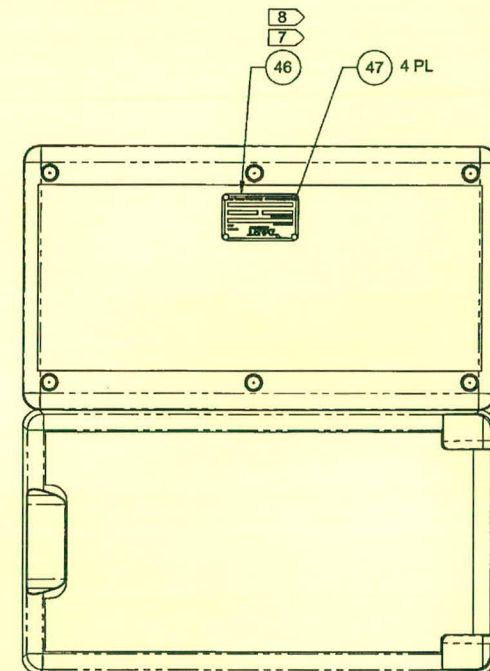
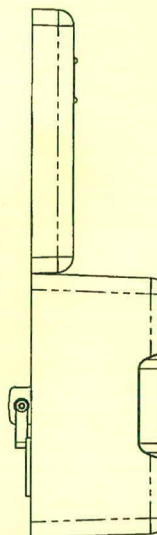
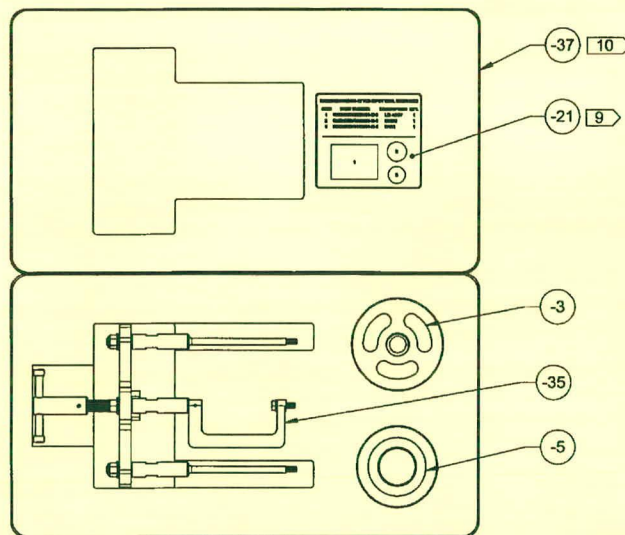
Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/20/18

ITEM #	QTY	PART #	PART TITLE
-3	1	RBEM652V3002101-M-3	GUIDE
-5	1	RBEM652V3002101-M-5	BASE
-21	1	RBEM652V3002101-M-21	CONTENT PLACARD
-35	1	RBEM652V3002101-M-35	LID ASSY
-37	1	RBEM652V3002101-M-37	PACKAGING ASSY
46	1	RB41011	DART PLACARD
47	4	McMaster#97524A032	SEALING BLIND RIVETS 1/8" DIA. x 0.425" LG.



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED

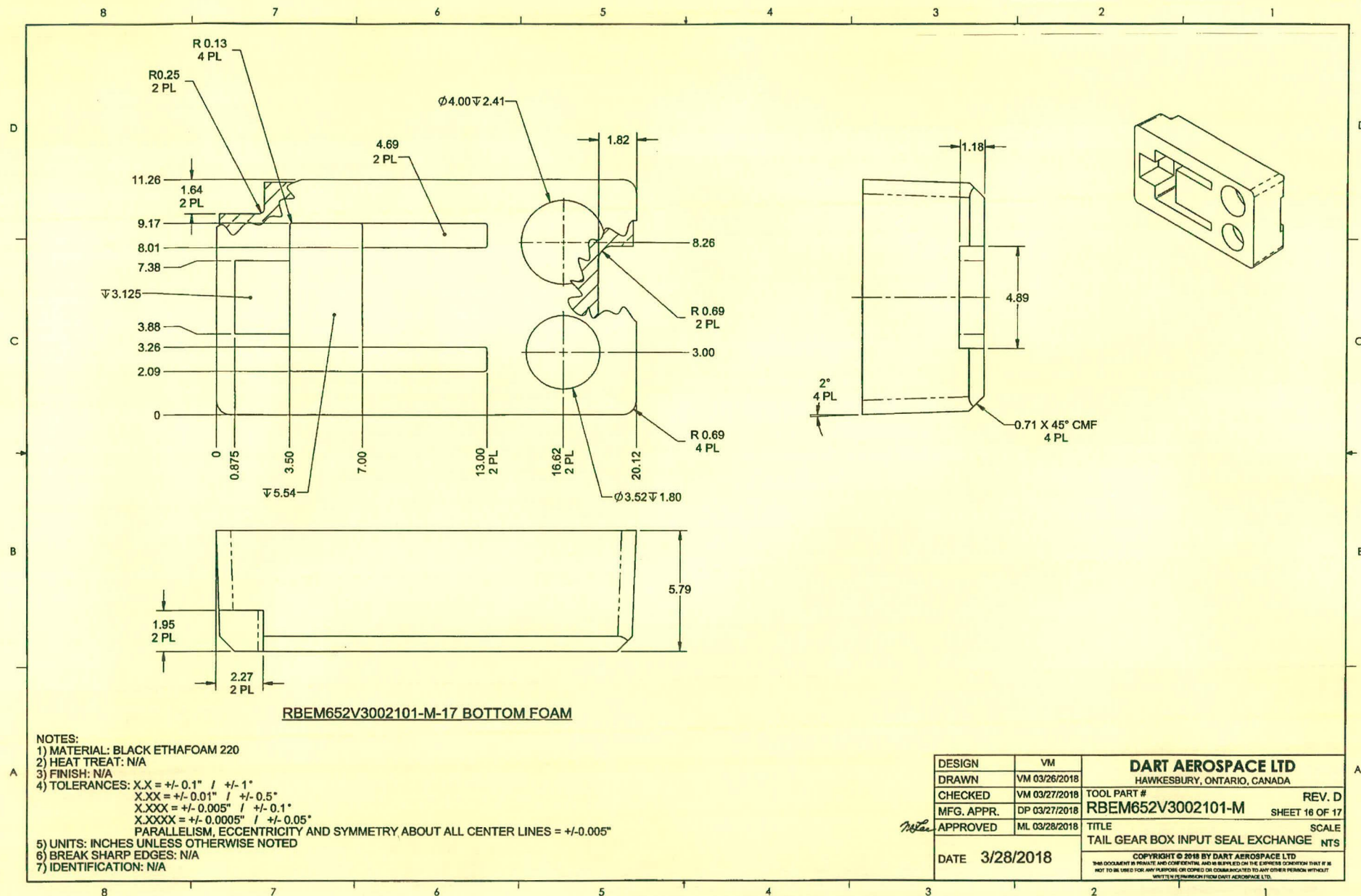
8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS

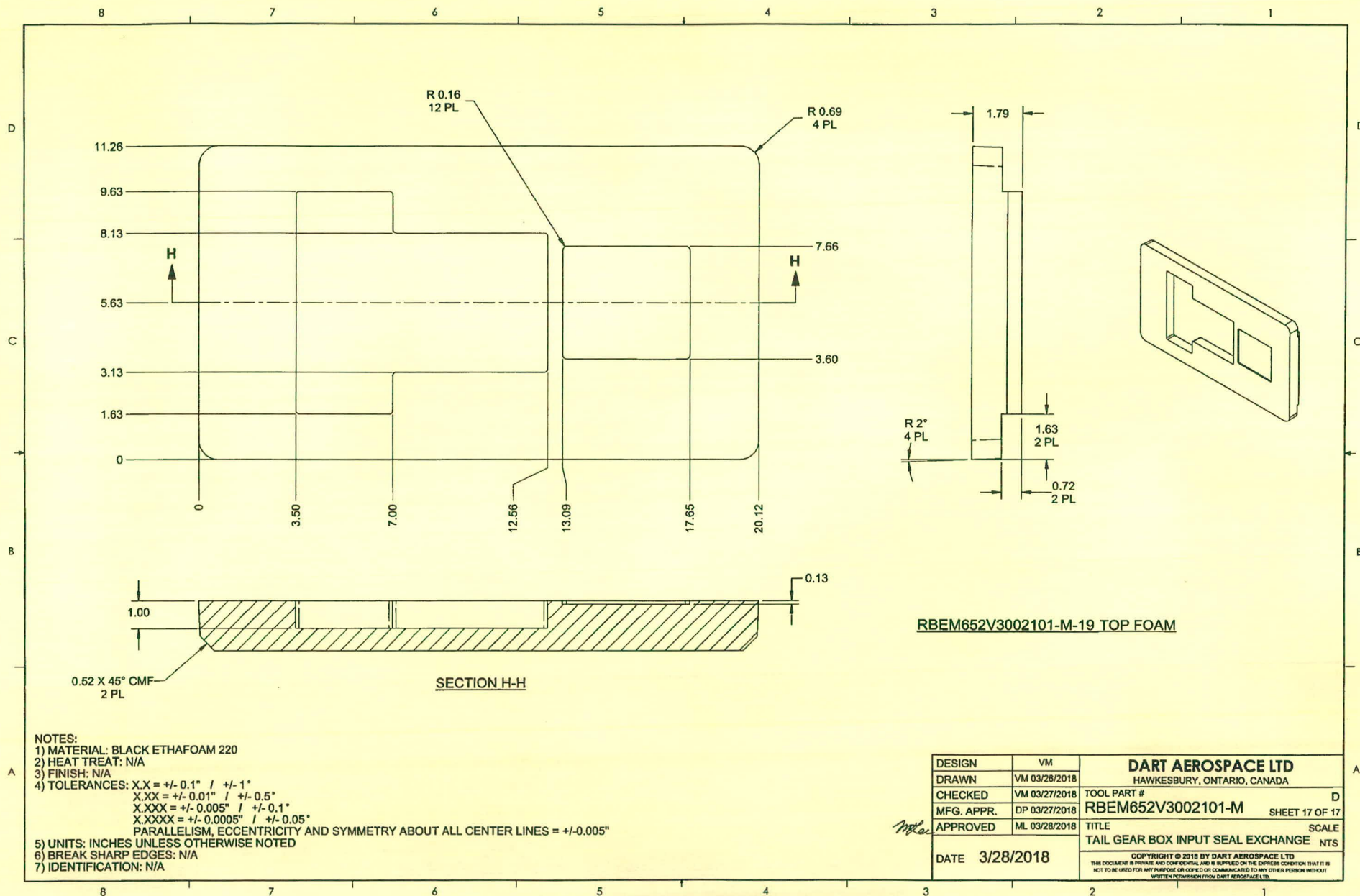
9) HOT GLUE THE PLASTIC PLACARD ONTO THE TOP FOAM

10) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

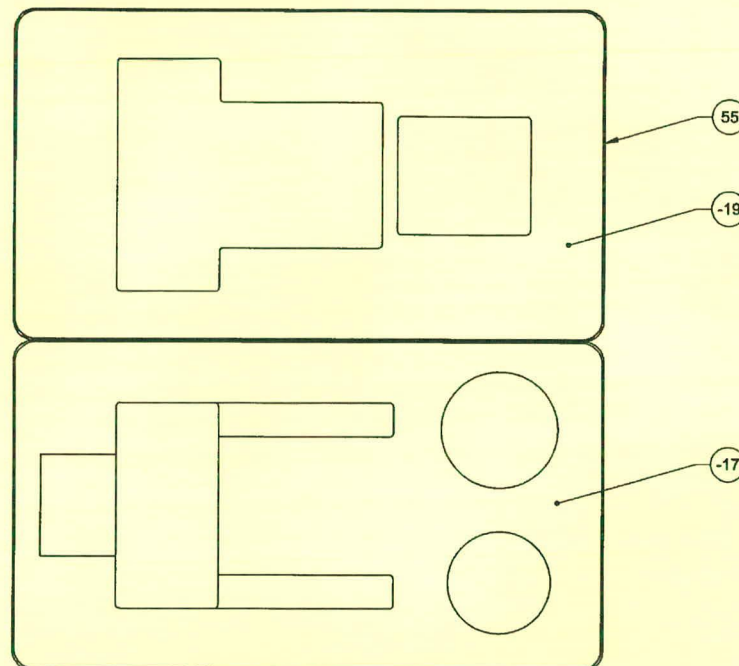
RBEM652V3002101-M TAIL GEAR BOX INPUT SEAL EXCHANGE

A	NEW ISSUE	17-805	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM 03/26/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM 03/27/2018	TOOL PART #	D
MFG. APPR.	DP 03/27/2018	RBEM652V3002101-M	SHEET 1 OF 17
APPROVED	ML 03/28/2018	TITLE	SCALE
DATE	3/28/2018	TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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ITEM #	QTY	PART #	PART TITLE
-17	1	RBEM652V3002101-M-17	BOTTOM FOAM
-19	1	RBEM652V3002101-M-19	TOP FOAM
55	1	PELICAN #APP-1510-E	PELICAN CASE 1510



RBEM652V3002101-M-37 PACKAGING ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM 03/26/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM 03/27/2018	TOOL PART #	REV. D
MFG. APPR.	DP 03/27/2018	RBEM652V3002101-M	SHEET 15 OF 17
APPROVED	ML 03/28/2018	TITLE	SCALE
DATE 3/28/2018		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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